

Work Order ID 82536

82536

Ship Mail

Page 1

Monday, April 02, 2012 3:10:29 PM

Item ID: D3914-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Long Basket Lid Assembly (350)
Start Date: 4/2/2012 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 4/27/2012 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: *[Signature]* Date: *12-04-12* Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3914	B								
D4020	A								
100	Weld per dwg A/R S.S. rod Batch: <i>4118161</i>	0.00							
100	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- assemble ribs , weld as per dwg D3914 using DT9607A ✓								
	2- weld hinge (3) and Mounting brackets as per dwg D3914 ✓								
	Visual inspect before welding mesh								
	3- tack weld mesh on basket as per dwg D3914								
	Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									
QC	Memo	0.00							
Quality Control									

(1x)

12.05.15

1x

12.05.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: D4030-044	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

8/2/12/15

83675.

1 0 12-5-15.

12/5/16

MF 12-05-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Page 1

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Work Order ID: 82536

82536

Parent Item: D3914-041

D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 4/2/2012

Required Date: 4/27/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
as per dwg revB DD 10.08.18 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2581

Manufactured

No

100

Each

31.0000

2

2

D2581

Mounting Bracket

**

B82017 → 2x *12.05.10*

Location

Loc Qty

Loc Code

WA005

31

69739

1

70766

2

77045

1

77523

1

81253

26

D3914-1

Manufactured

No

100

Each

20.0000

2

2

D3914-1

Rib

**

12.05.10

Location

Loc Qty

Loc Code

WA

6

81407

4

WA006

14

81449

12

82130

2

82131

2

D3914-7

Manufactured

No

100

Each

6.0000

2

2

D3914-7

Rib

**

B84233 → 2x *12.05.10*

Location

Loc Qty

Loc Code

WA006

6

Dart Aerospace Ltd

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Page 2

Monday, April 02, 2012 3:10:34 PM

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Parent Item: D3914-041

D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 4/2/2012

Required Date: 4/27/2012

Start Qty: 1.00

Required Qty: 1.00

D4016-3 Manufactured No

100 Each 18.0000 3 3

D4016-3

Hinge Half, Lid

**

B82968 → 3x *SD 12.05.10*

Location

Loc Qty

Loc Code

WA

18

81389

18

D4018-5 Manufactured No

100 Each 17.0000 9 9

D4018-5

Rib

**

B83869 → 9x *SD 12.05.10*

Location

Loc Qty

Loc Code

WA005

17

80776

7

81448

10

D4020-5 Manufactured No

100 Each 1.0000 1 1

D4020-5

Mesh (350 Basket Long, Lid)

**

B82513 → 1x *SD 12.05.10*

Location

Loc Qty

Loc Code

WA

1

81180

1

D4021-3 Manufactured No

100 Each 11.0000 1 1

D4021-3

Data Plate

**

B81451 → 1x *SD 12.05.10*

Location

Loc Qty

Loc Code

WA

11

80897

11

Monday, April 02, 2012 3:10:35 PM

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Page 2

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D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 4/2/2012

Required Date: 4/27/2012

Start Qty: 1.00

Required Qty: 1.00

D4035-041

Manufactured No

100

Each

7.0000

1

1

D4035-041

Lid Rib Assembly, Fwd (350 Basket)

**

B83231 → 1x *W* 12.05.10

Location

Loc Qty

Loc Code

WA

7

63720

0

81450

6

81701

1

D4035-043

Manufactured No

100

Each

5.0000

1

1

D4035-043

Lid Rib Assembly, Aft (350 Basket)

**

B83232 → 1x *W* 12.05.10

Location

Loc Qty

Loc Code

WA

5

81452

5

D2728-3

Manufactured No

140

Each

0.0000

1

1

D2728-3

Dart Logo label

**

115000.

1 *BR* 12.5.10.

Monday, April 02, 2012 3:10:35 PM

Shop Packet Print

Page 3

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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE

D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82536

RD12-041-2

RELEASED
10.08.17
ECN 10-596

B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS		
DRAWN			
CHECKED	SC		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.08.05		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3914 REV. B SHEET 1 OF 4 TITLE LONG BASKET LID ASSY (350) NTS SCALE COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

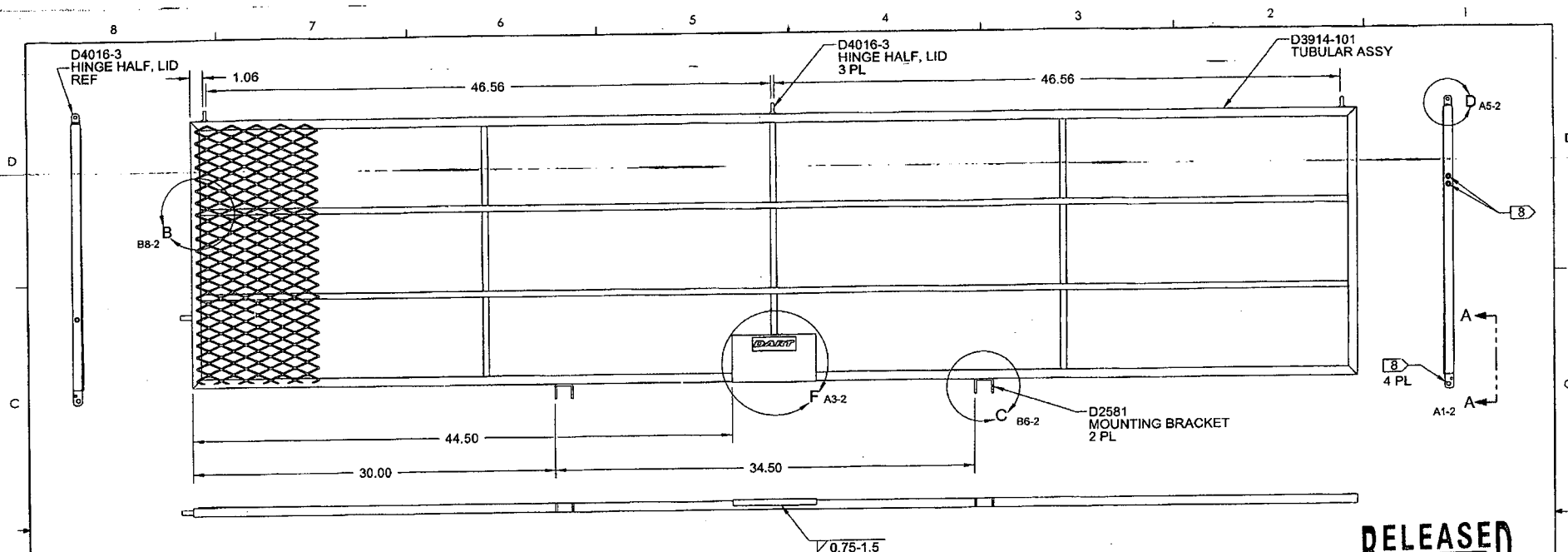
Dart Aerospace Ltd

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Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

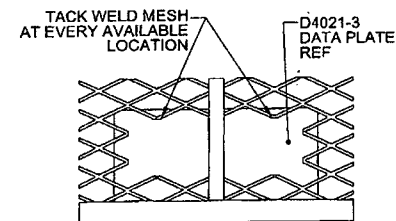
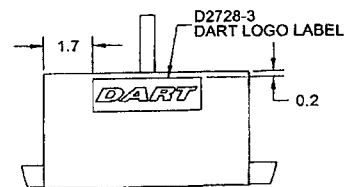
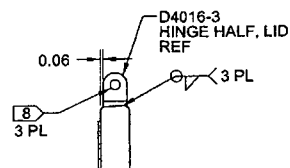
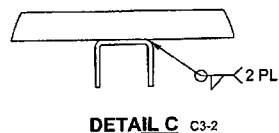
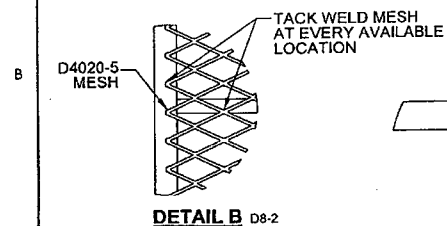
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NOTE: Date & initial all entries



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)



RELEASED
10.08.12 up



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

82534

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3914	REV. B
MFG. APPR.		SHEET 2 OF 4	
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET LID ASSY (350)	
DATE	10.08.05	NTS	
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

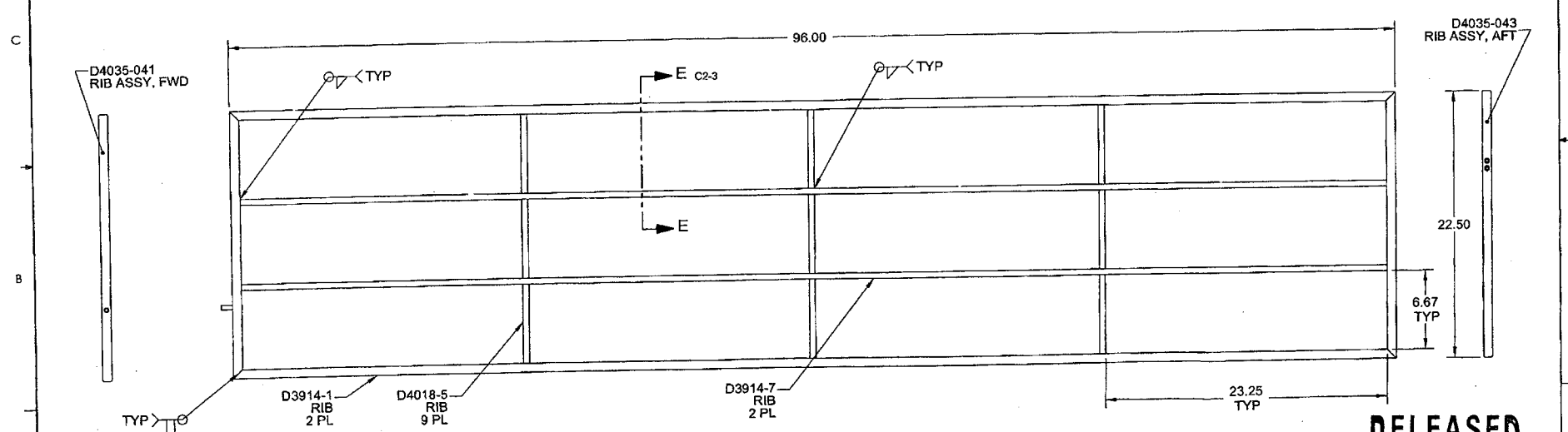
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3



8 D3914-101 TUBULAR ASSY, LONG LID

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 14.10 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS :0.06 FOR D4018-101
 - 9) WELD PER DART QSI 004

DESIGN	AL5	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RC	DRAWING NO.	REV. B
CHECKED	W2	D3914	SHEET 3 OF 4
MFG. APPR.	W2	TITLE	SCALE
APPROVED	W2	LONG BASKET LID ASSY (350)	NTS
DE APPR.	W2	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, REPRODUCED OR CONTAINED IN ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.08.05		

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10-08-12 4P

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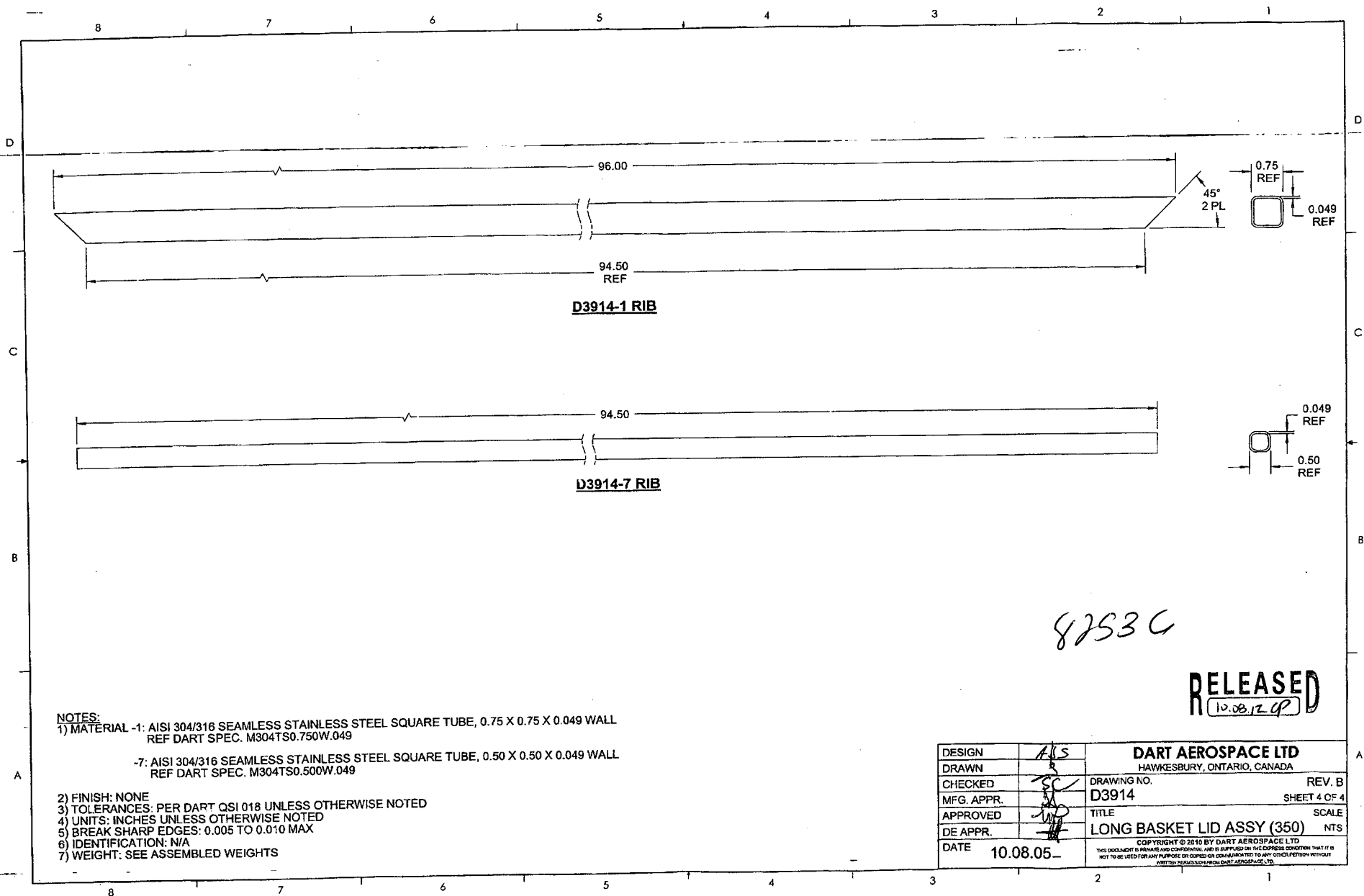
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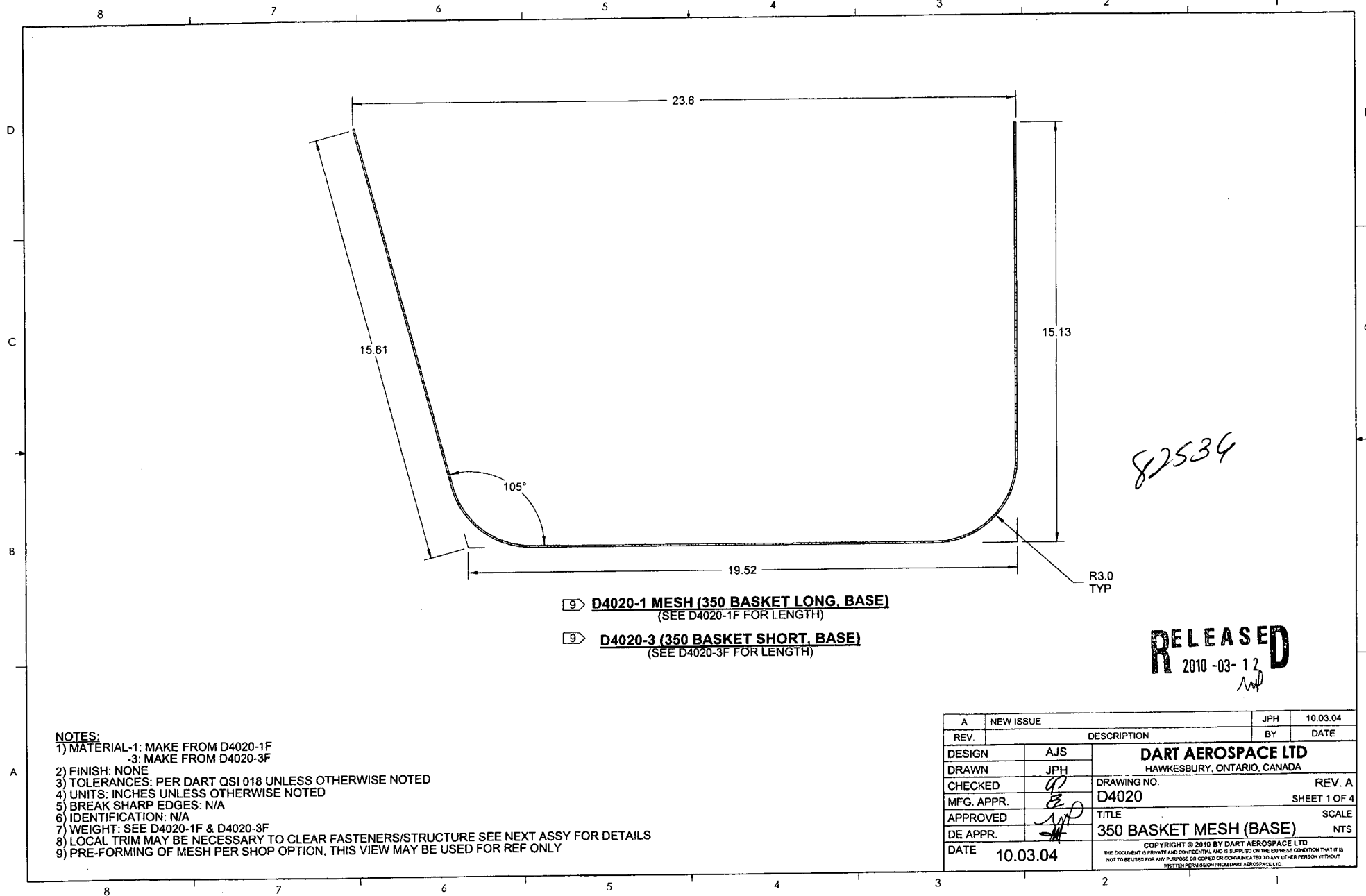
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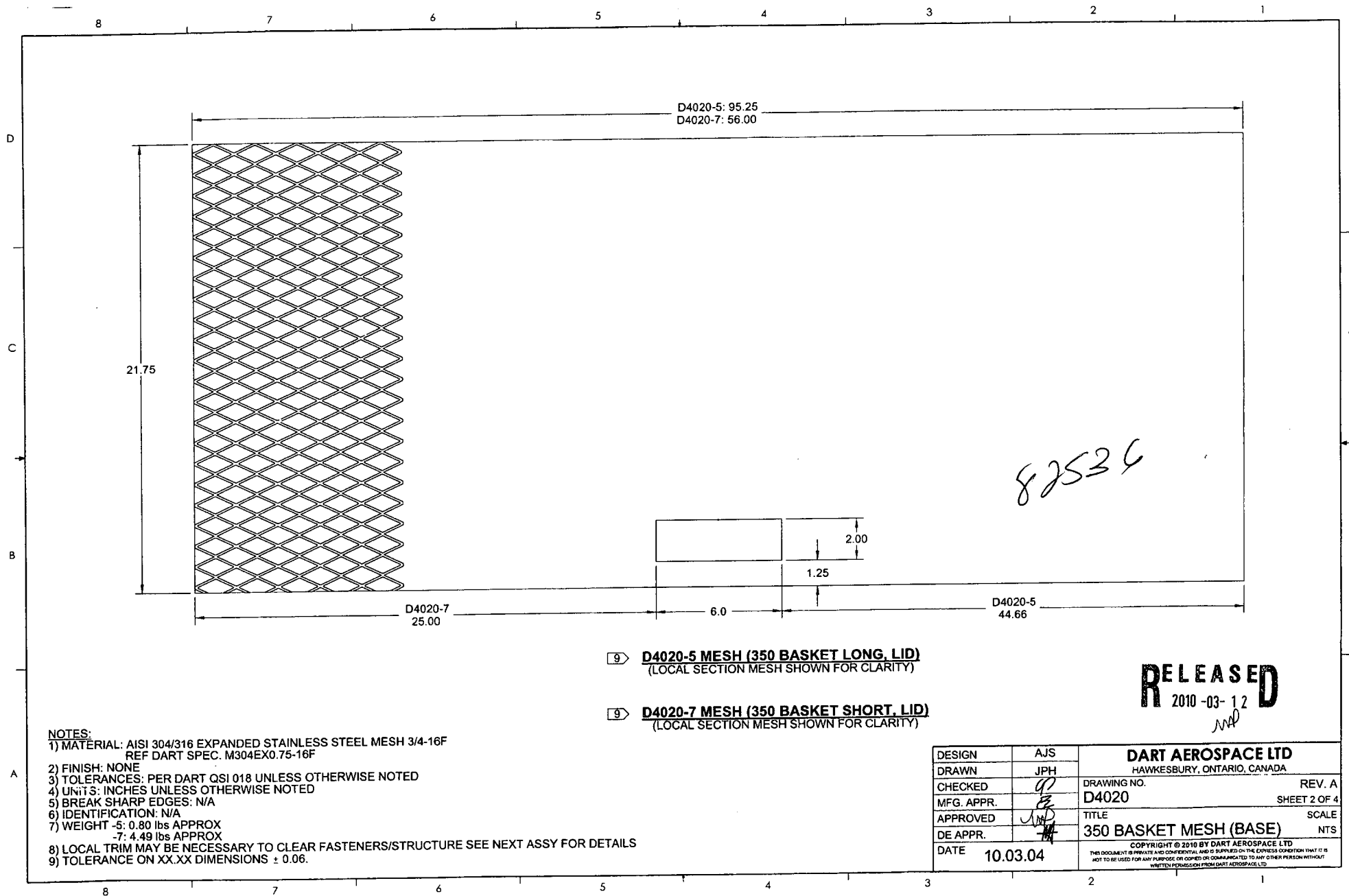
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9) **D4020-5 MESH (350 BASKET LONG, LID)**
(LOCAL SECTION MESH SHOWN FOR CLARITY)

9) **D4020-7 MESH (350 BASKET SHORT, LID)**
(LOCAL SECTION MESH SHOWN FOR CLARITY)

NOTES:

1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: N/A

7) WEIGHT -5: 0.80 lbs APPROX

-7: 4.49 lbs APPROX

8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS

9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

RELEASED
2010-03-12
NND

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. A
MFG. APPR.	JP	D4020	SHEET 2 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	350 BASKET MESH (BASE)	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

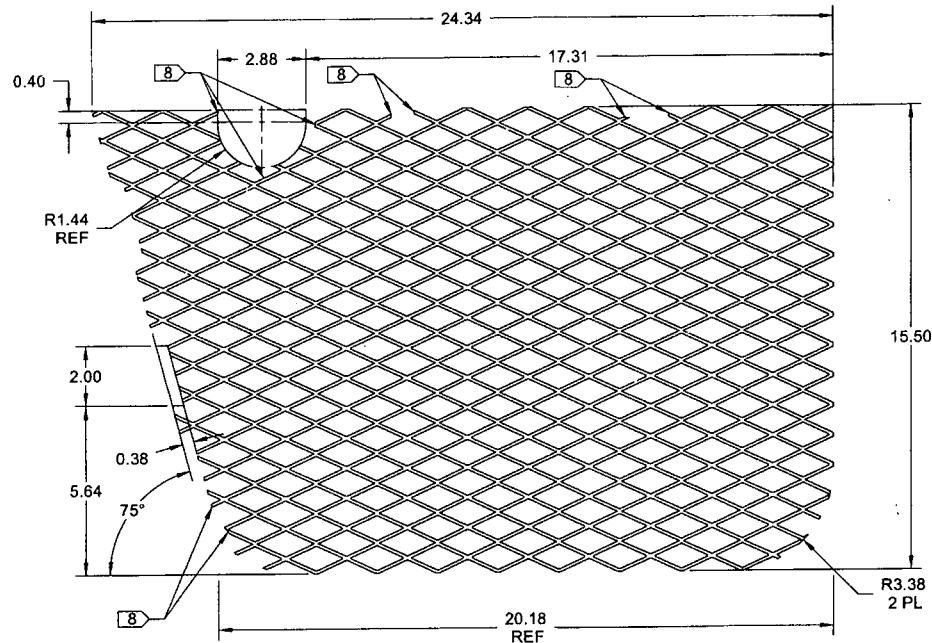
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9 D4020-11 END MESH, BASKET

82536

RELEASED
2010-03-12
MD

NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.22 lbs
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	GP	DRAWING NO.	REV. A
MFG. APPR.	B	D4020	SHEET 3 OF 4
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	350 BASKET MESH (BASE)	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

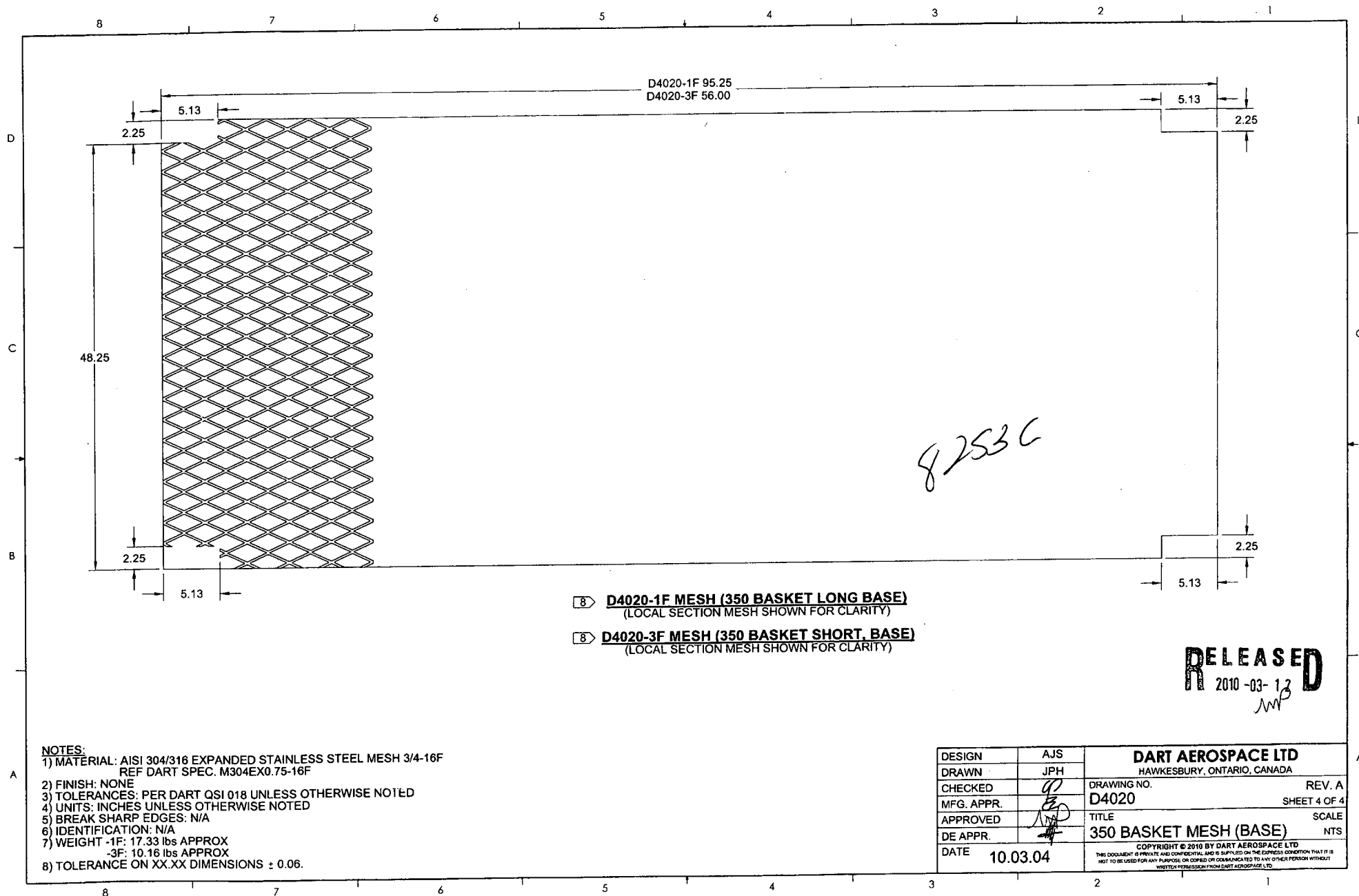
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NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries